

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014538**Date Inspected:** 18-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Zhou cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 3G-005 located on PCMK SEG3001F of Segment 12AE welder is identified as 044790. ZPMC QC is identified as Mr. Wang xu. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

SMAW welding of weld joint 4G-009 located on PCMK SEG3001AA of Segment 12AE welder is identified as 067752. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint 4G-017 located on PCMK SEG3001AA of Segment 12AE welder is identified as 037976. ZPMC QC is identified as Mr. Wang xu . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

FCAW welding of weld joint 3G-029 located on PCMK SEG3001AL of Segment 12AE welder is identified as 044824. ZPMC QC is identified as Mr. Zhong guo hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 2F-003 located on PCMK SEG3006C of Segment 12CW welder is identified as

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204730. ZPMC QC is identified as Mr. Tao wei . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 3G-004 located on PCMK SEG3006F of Segment 12CW welder is identified as 047866. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2133-B-Us-F.

SMAW welding of weld joint 4F-270 located on PCMK DP3042-001 of Segment 12AW welder is identified as 067113. ZPMC QC is identified as Mr. Xu tao . The welding variables recorded by QC appeared to Comply with the WPS-B-P-2114-FCM-1.

During in process inspection it is found that in segment 12CW by Visually the weld joint fit-up of Corner assembly to side plate complete joint penetration weld has 10~20mm root gap those location marked and informed to ZPMC QC Mr. Xu tao , he agreed and will arrange WR for the repair work.

During in process inspection it is found that in segment 12CW by visually the weld joint fit-up of Floor beam flange is identified as FB3096 to Corner assembly flange is identified as CA3011 at PP116.5 (south side) misaligned 10mm. ZPMC not yet start any welding. They have sent this issue to their Technical engineer for further fabrication.

BAY#16

This QA inspector performed 10% UT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as Tower Facade. The weld designations reviewed are as follows:
NWIT-005760

WD1-SA4-55A/B-4-1.

BAY#19

Fit-up of bearing plate is in progress in BK004A-002.

BLAST SHOP

Visual Inspection after Blast at West Tower Lift -1 This Quality Assurance (QA) Inspector performed random visual inspection of North Tower lift -1 all skin plate (A to E) height 0 meter to 47.6 meter after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
